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Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3914-041
Job Sheet 174793



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV:C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/14/18	4/14/18	0.00	0.00	Start Up Large Fab-5		D.M. 18-3-29
100	Large Fab	1 pcs	4/14/18	4/14/18	0.00	6.67	Large Fab 1	8h	18-03-29
110	QC	1 pcs	4/14/18	4/14/18	0.00	0.00	QC9		18-04-10
120	QC	1 pcs	4/14/18	4/14/18	0.00	0.00	QC5		18-04-10
130	Powdercoat	1 pcs	4/14/18	4/14/18	0.00	0.40	Powdercoat4		18-4-16
135	QC	1 pcs	4/14/18	4/14/18	0.00	0.00	QC3		18-4-16
140	HandFinish	1 pcs	4/16/18	4/16/18	0.00	0.80	HandFinish3		18-4-16
150	QC	1 pcs	4/16/18	4/16/18	0.00	0.00	QC3		18-4-16
160	Packaging	1 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-2		18-4-16
170	QC21-SA	1 Ea	4/16/18	4/16/18	0.00	0.00	QC21		21 APR 17 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138700 START: 9:25 O.V.T: 320° FINISH: 9:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5053024
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5049106
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5038793
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5047820
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5050470
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5042803
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5050240

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	54	0
	D3914-1	2	11	0
	D3914-7	2	10	0
	D4016-3	3	58	0
	D4018-5	9	21	0
	D4020-5	1	9	0
	D4021-3	1	7	0
	D4035-043	2	10	0
Part Specifications				
Specifications could not be found.				

Plex 3/21/18 1:34 PM Dart.Gagnon.Michelle

Master Unit 001940



Job No 174793



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Container No: S056917



Part: D3914-041

Job No: 174793

Serial No/Batch: S056917

Revision: A/D

Inspector:

Date: 03/29/18